

Date: Thursday, 2/14/2008 10:56:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE LH (209)
Job Number	: 37421		
Estimate Number	: 11598		
P.O. Number	:	Part Number	: D29181
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2918 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	:	Due Date	: 3/3/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JA 08.02.14</u>		
Comment	: Est: A 04.07.16 New Issue KJ/JLM est B 07.08.07 ECN930 EC verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102011	6061-T6 8.25x6.5x2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

6061-T6 8.25x6.5x2.5

Cut blanks: 2.500" x 8.250" x 6.50" grain along 6.50"

Material: 6061-T6/T651 (QQ-A-250/11)

(D6102-011)

Identify as D2918-1

Batch: B3760

mk 08/03/12

⑥

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number

Machine Step No 1 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Machine Step No 2 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Machine Step No 3 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Deburr

mk/SA 08/03/13

⑥

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per Dwg D2918 & attached dimension sheet

mk/SA 08/03/13

⑥

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 28/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:56:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE LH (209)

Job Number: 37421

Part Number: D29181

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MR/SA 08/03/15

(6)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.F 08/03/13

(6)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-A

08/03/14

(6X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107605

M-A

08/03/15

(6X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

A-m

08.03.15

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/3/17

50

(6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/03/17

Job Completion



W 08-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 37421
Description: Saddle LH	Part Number: D2918-1
Inspection Dwg: D2918 Rev. <i>ATB</i> <i>08.02.14</i>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2918 Rev. A1 and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.090	0.110		.093	.100	.100	.100		
B	0.175	0.205		.192	.190	.185	.192		
C	0.175	0.217		.178	.183	.179	.186		
D	R0.470	0.530		.500	.500	.500	.500		
E	0.740	0.760		.758	.755	.755	.758		
F	0.277	0.297		.280	.283	.279	.278		
G	3.170	3.230		3.197	3.195	3.155	3.193		
H	0.180	0.220		.182	.180	.180	.180		
I	1.599	1.614		1.614	1.612	1.612	1.612		
J	0.250	0.270		.267	.260	.260	.262		
K	4.436	4.446		4.436	4.437	4.437	4.437		
L	1.498	1.508		1.502	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		.053	.063	.063	.063		
O	1.103	1.113		1.107	1.107	1.107	1.107		
P	1.225	1.235		1.231	1.230	1.230	1.230		
Q	0.257	0.262		.260	.259	.260	.260		
<i>(R)</i>	<i>1.900</i>	<i>2.010</i>							
S	1.385	1.400		1.397	1.395	1.397	1.398		
T	0.760	0.765		.760	.760	.760	.760		
U	0.307	0.312		.310	.310	.310	.310		
V	0.615	0.635		.623	.625	.626	.627		
W	0.438	0.443		.441	.441	.441	.441		
X	0.490	0.510		.496	.495	.495	.495		
Y	1.745	1.755		1.751	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		7.996	8.002	8.002	8.002		
AB	2.000	2.020		2.000	2.000	2.000	2.000		
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>gml/SD</i>
Date: <i>08/03/13</i>

Audited by: <i>SF</i>
Date: <i>08/03/13</i>

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 37421
Description: Saddle LH	Part Number: D2918-1
Inspection Dwg: D2918 Rev. <i>A1 B</i> <i>08.12.14</i>	Page 1 of 1

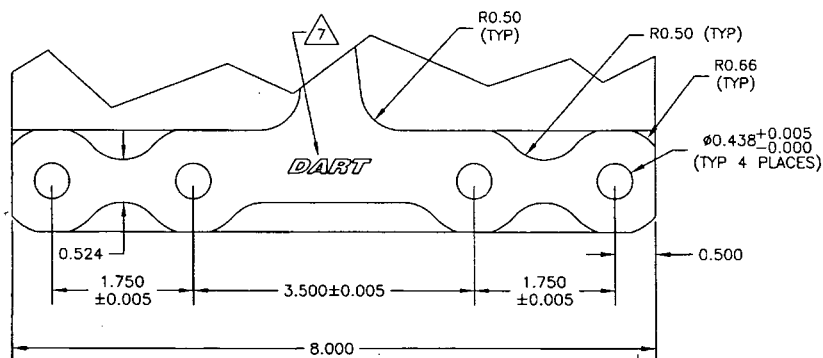
Inspect dimensions highlighted on inspection sheet drawing D2918 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.090	0.110		<i>.100</i>	<i>.100</i>				
B	0.175	0.205		<i>.289</i>	<i>.290</i>				
C	0.175	0.217		<i>.183</i>	<i>.181</i>				
D	R0.470	0.530		<i>.500</i>	<i>.500</i>				
E	0.740	0.760		<i>.755</i>	<i>.750</i>				
F	0.277	0.297		<i>.275</i>	<i>.278</i>				
G	3.170	3.230		<i>3.195</i>	<i>3.195</i>				
H	0.180	0.220		<i>.180</i>	<i>.180</i>				
I	1.599	1.614		<i>1.612</i>	<i>1.612</i>				
J	0.250	0.270		<i>.261</i>	<i>.260</i>				
K	4.436	4.446		<i>4.440</i>	<i>4.440</i>				
L	1.498	1.508		<i>1.504</i>	<i>1.504</i>				
M	1.278	1.288		<i>1.283</i>	<i>1.283</i>				
N	0.053	0.073		<i>.063</i>	<i>.063</i>				
O	1.103	1.113		<i>1.108</i>	<i>1.108</i>				
P	1.225	1.235		<i>1.230</i>	<i>1.230</i>				
Q	0.257	0.262		<i>.261</i>	<i>.261</i>				
R	<i>1.990</i>	<i>2.010</i>							
S	1.385	1.400		<i>1.397</i>	<i>1.397</i>				
T	0.760	0.765		<i>.760</i>	<i>.760</i>				
U	0.307	0.312		<i>.310</i>	<i>.310</i>				
V	0.615	0.635		<i>.624</i>	<i>.625</i>				
W	0.438	0.443		<i>.440</i>	<i>.440</i>				
X	0.490	0.510		<i>.498</i>	<i>.498</i>				
Y	1.745	1.755		<i>1.750</i>	<i>1.750</i>				
Z	3.495	3.505		<i>3.500</i>	<i>3.500</i>				
AA	7.990	8.010		<i>8.002</i>	<i>8.002</i>				
AB	<i>2.000</i>	<i>2.020</i>		<i>2.001</i>	<i>2.001</i>				
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SD</i>
Date: <i>08/03/13</i>

Audited by: <i>S.F</i>
Date: <i>08/03/13</i>

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM <i>AK</i>	<i>AK</i>

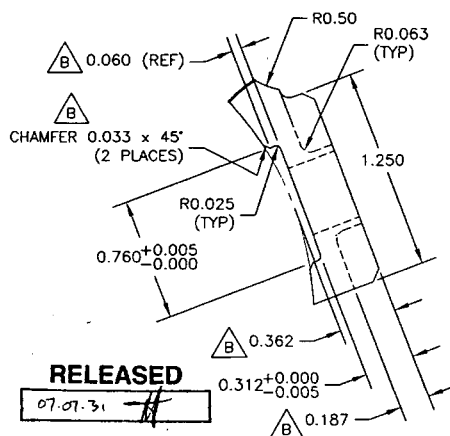


VIEW B-B

D2918-1 LH SADDLE (SHOWN)
D2918-2 RH SADDLE (OPPOSITE)

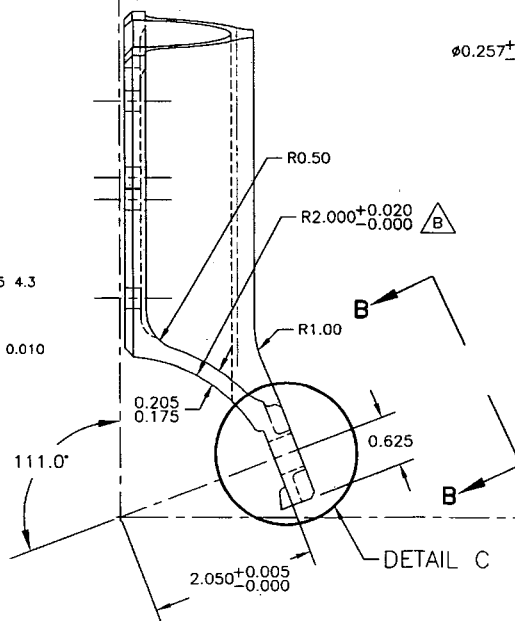
NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART OSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



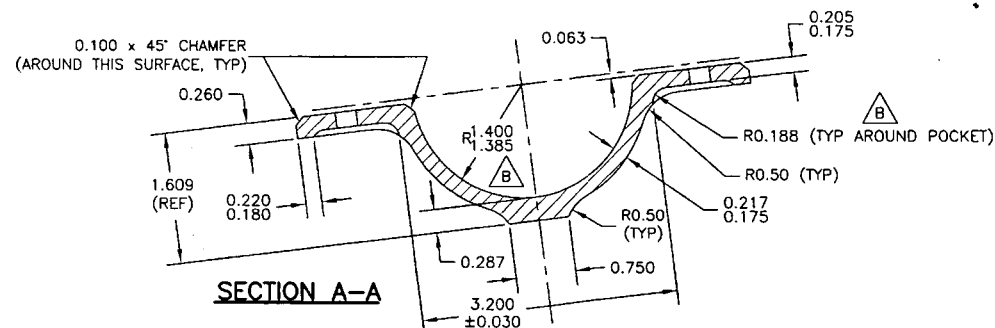
RELEASED

07.07.31

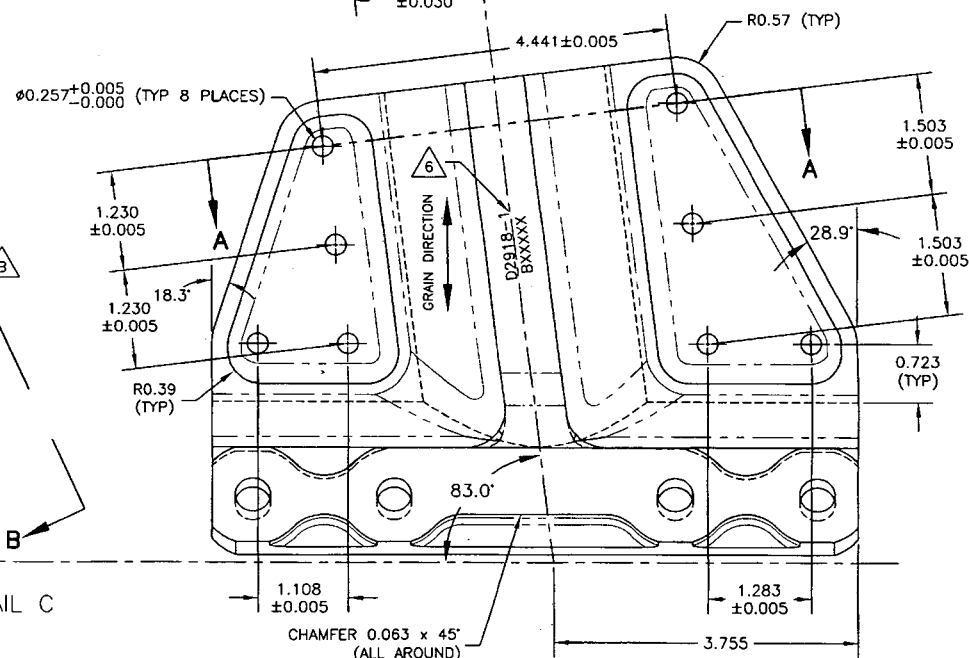


DETAIL C
 SCALE 4:3

NO. 37421
 WORK ORDER
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 ENGINEERING
 RETURN TO
 SHOP COPY



SECTION A-A



B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	GP	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.02.19	TITLE
		SADDLE

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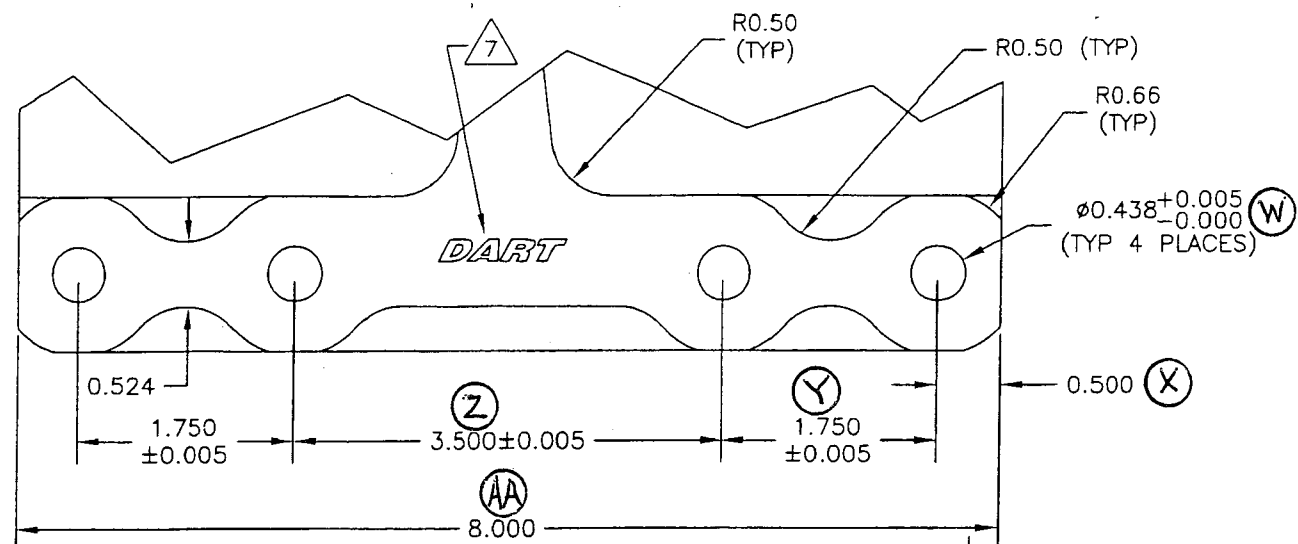
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 DART AEROSPACE LTD.

DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
 D2918

REV. B
 SHEET 1 OF 1

SCALE
 2:3

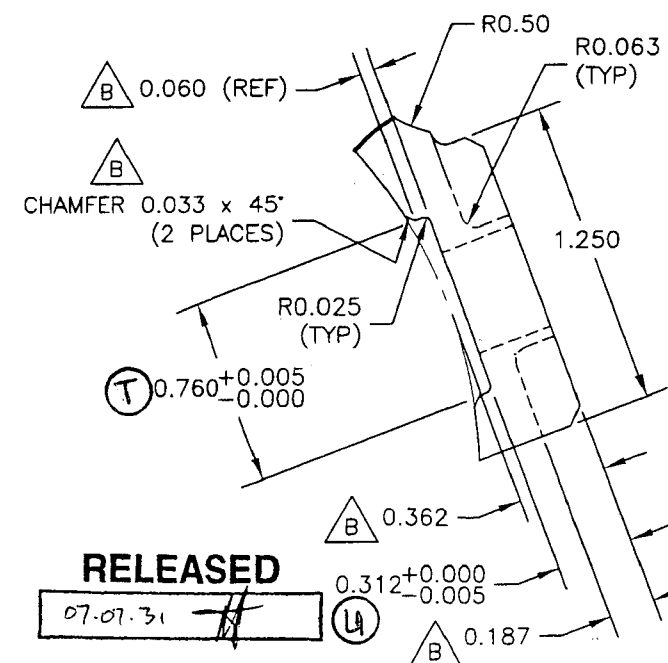


VIEW B-B

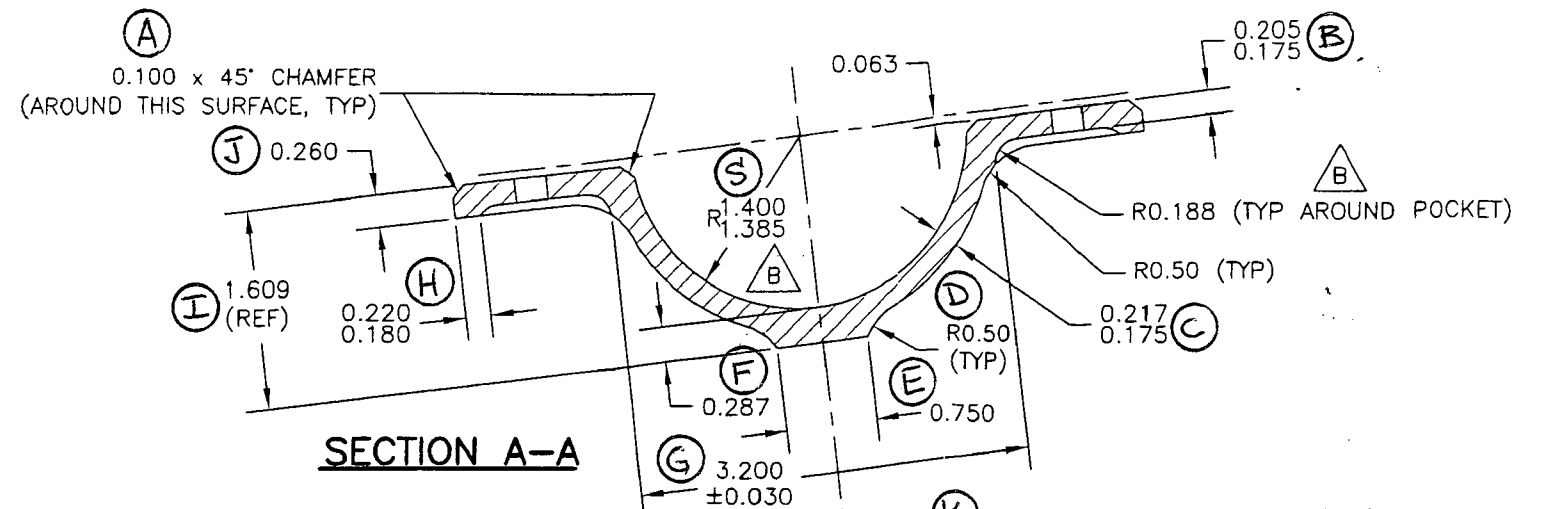
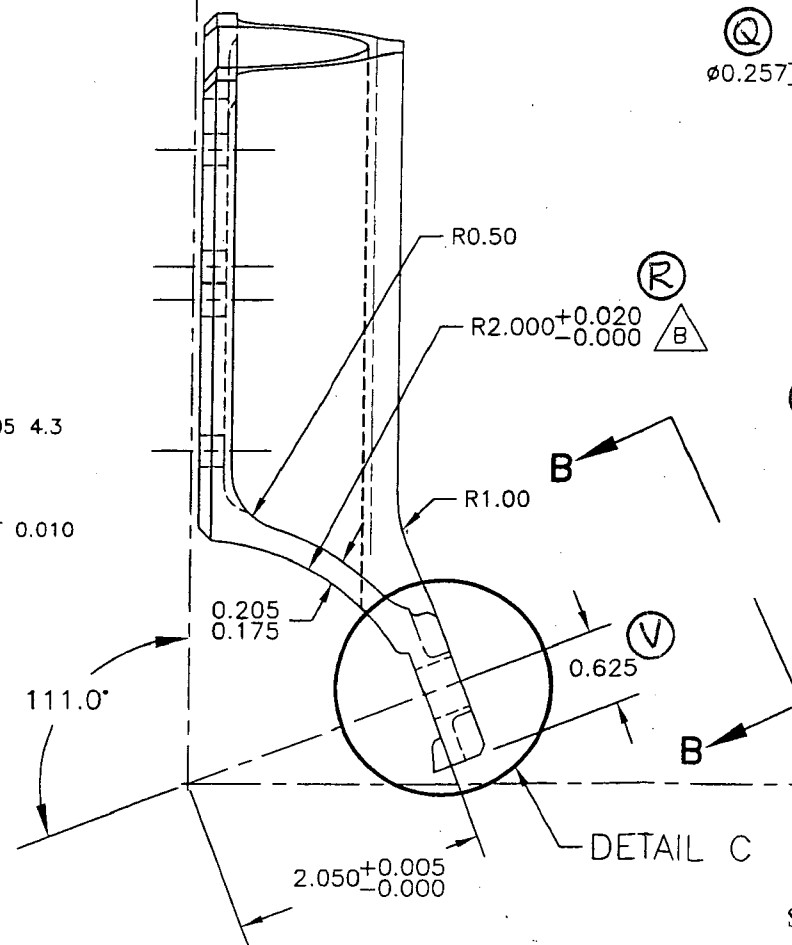
D2918-1 LH SADDLE (SHOWN)
D2918-2 RH SADDLE (OPPOSITE)

NOTES:

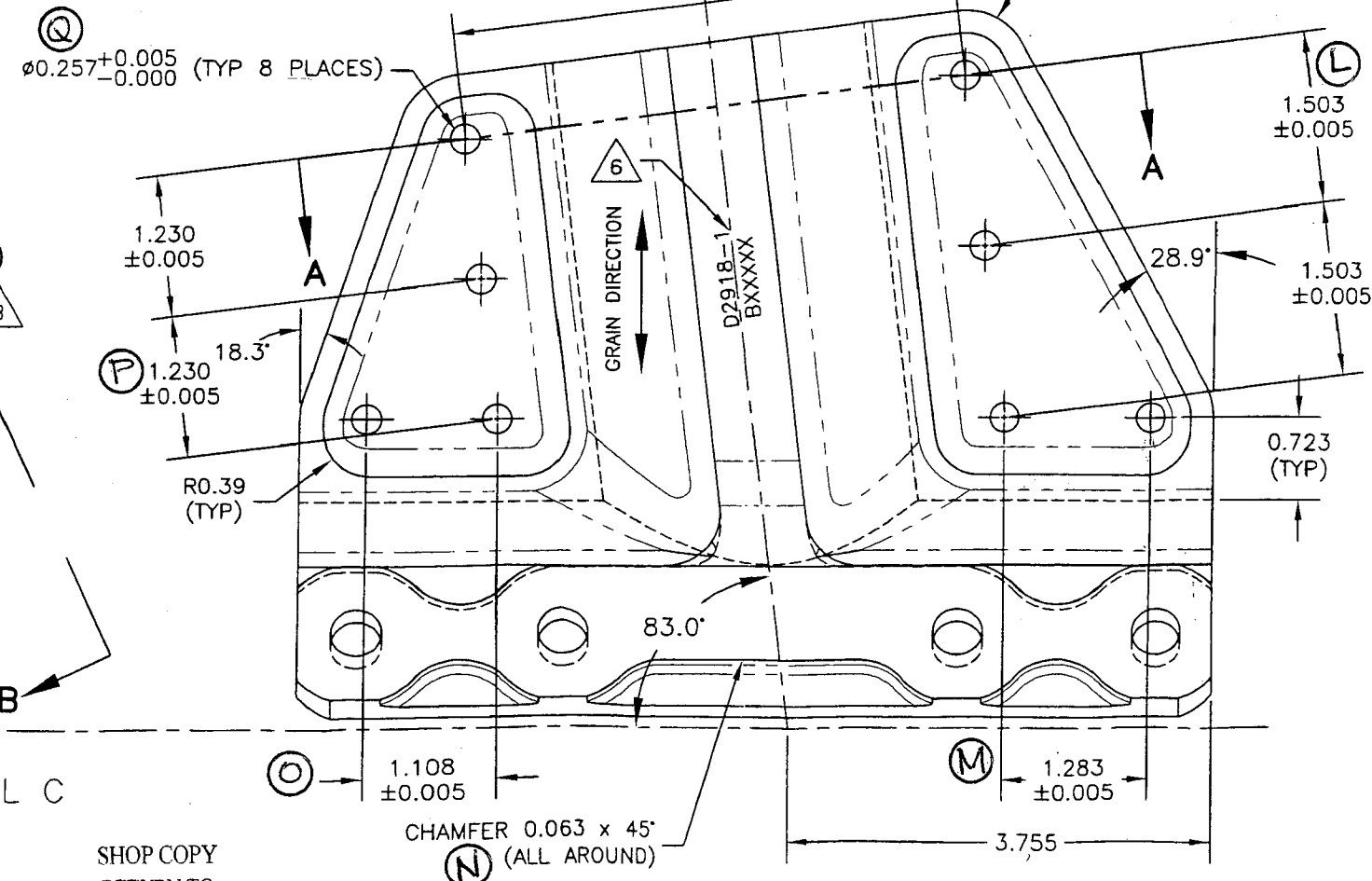
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



DETAIL C
 SCALE 4:3



SECTION A-A



SHOP COPY
 RETURN TO
 ENGINEERING
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 WITHOUT NOTICE

CONTROLLED SHOP COPY

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 DART AEROSPACE LTD.

B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	9P	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.02.19	TITLE
		SADDLE
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
		REV. B SHEET 1 OF 1 SCALE 2:3